

121 10 JFC 2014-02-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | |
|--|--|--|--|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 112729

February-06-14 10:46:22 AM

112729

Page 2

Item ID: D2743

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crossbolt Spacer

Start Date: 2/06/14 Start Qty: 120.00

120

Cust Item ID:

Required Date: 2/20/14 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|---------------------|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | 121 | Ø | | DAS 40 2-8-14 |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | 14/02/14 |
| 130 | | 0.00 | | | | | | | |
| *130* | | | | | | 121 | Ø | 14-2-24 | DG |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1- Clean crossbolt spacer with ultra bright aluminum cleaner | | | | | | | | |
| 160 | Identify as per dwg & Stock Location: 4/6 | 0.00 | | | | | | | |
| *160* | | | | | | 121 | Ø | 14-2-25 | DG |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | ***STOCK IN SKIDTUBE CELL*** | | | | | | | | |

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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
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FAULT CATEGORY

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|--|--|---|--|

Work Order ID 112729

112729

Page 3

February-06-14 10:46:22 AM

Item ID: D2743

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crossbolt Spacer

Start Date: 2/06/14 Start Qty: 120.00

120

Cust Item ID:

Required Date: 2/20/14 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MLJ 14-02-26

ME
14-2-26

DQA: _____ Date: _____



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FAULT CATEGORY

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|--|--|---|--|

Picklist Print

February-06-14 10:46:28 AM

Page 1

Work Order ID: 112729

112729

Parent Item: D2743

D2743

Parent Item Name: Crossbolt Spacer

Start Date: 2/06/14

Required Date: 2/20/14

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP E05.04.13Reformat; removed tumble and deburr stepKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6T0.625W.065 | | Purchased | No | | | 100 | f | 135.0820 | 0.2667 | 34 | | | |

M6061T6T0 625W 065

**

6061-T6 RD Tube .625 x.065W

Location

Loc Qty

Loc Code

MAT014

135.082

125593

135.082

34 JFL 2014-02-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

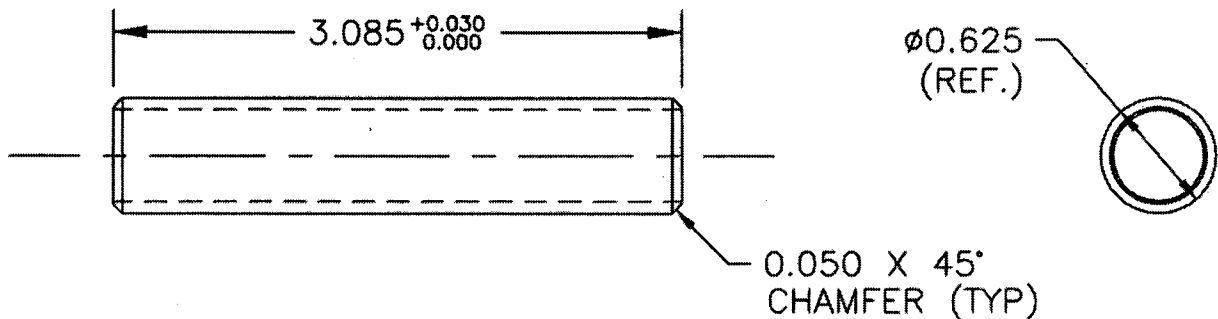
FAULT CATEGORY

| | | | |
|--|--|---|--|
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|--|--|---|--|



| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>HA</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. BELLEVUE, WA | |
| CHECKED <i>HA</i> | APPROVED <i>KE</i> | DRAWING NO. D2743 | REV. B SHEET 1 OF 1 |
| DATE 98.12.08 | | TITLE CROSS BOLT SPACER | SCALE 1:1 |
| A | 98.04.16 | NEW ISSUE | |
| B | 98.12.08 | 3.085 WAS 3.060 | |

RELEASED
98.12.16 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 112729

1402-06
MCS

MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED